

Date: Wednesday, 1/23/2008 11:38:10 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	DOUBLER		
Job Number	36927			Part Number	D2910		
Estimate Number	11591			Drawing Number	D2910 REV A		
P.O. Number				Project Number	N/A		
This Issue	1/23/2008	S.O. No.		Drawing Revision	A		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	1/30/2008	Qty:	40
Previous Run	31827			Um:	Each		
Written By	<i>JM</i> 080123						
Checked & Approved By							
Comment	Est B 02.11.12 Re-format; Incorporated D2911 and D2912 K J Est Rev:C Now on Waterjet 07-01-23 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S090	6061-T6 .090 Sheet
 Comment: Qty.: 0.1623 sf(s)/Unit Total : 6.4932 sf(s) 6061-T6 .090 Sheet Material: Sheet 6061-T6 x 0.090" thick (M6061T6S.090) Batch: <u>19059</u> <i>FB 8-1-28</i>		
2.0	WATER JET	FLOW WATER JET
 Comment: FLOW WATER JET 1-Cut as per Dwg D2910 Dwg Rev: <u>A</u> <i>FB 8-1-28</i> Prog Rev: <u>A</u> <i>(44)</i>		
2-Deburr if necessary <i>FB 8-1-28</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 <i>FB 8-1-29</i>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 <i>(44) counts</i>		
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/02/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:38:10 AM  
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Drawing Name: DOUBLER

Job Number: 36927

Part Number: D2910

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1

SB 08/02/08

(44)

6.0 CHEMICAL TREAT Hand Finish CHEMICAL TREATMENT

6/08/08



Comment: CHEMICAL TREATMENT Chemical Conversion

08-02-08

X44

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/08 X44

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST53

AS 08/02/08 X44

(44)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

Job Completion



2008/2/01

44

W

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36927
Description: Doubler	Part Number:	D2910
Inspection Dwg: D2910	Rev: A	Page 1 of 1

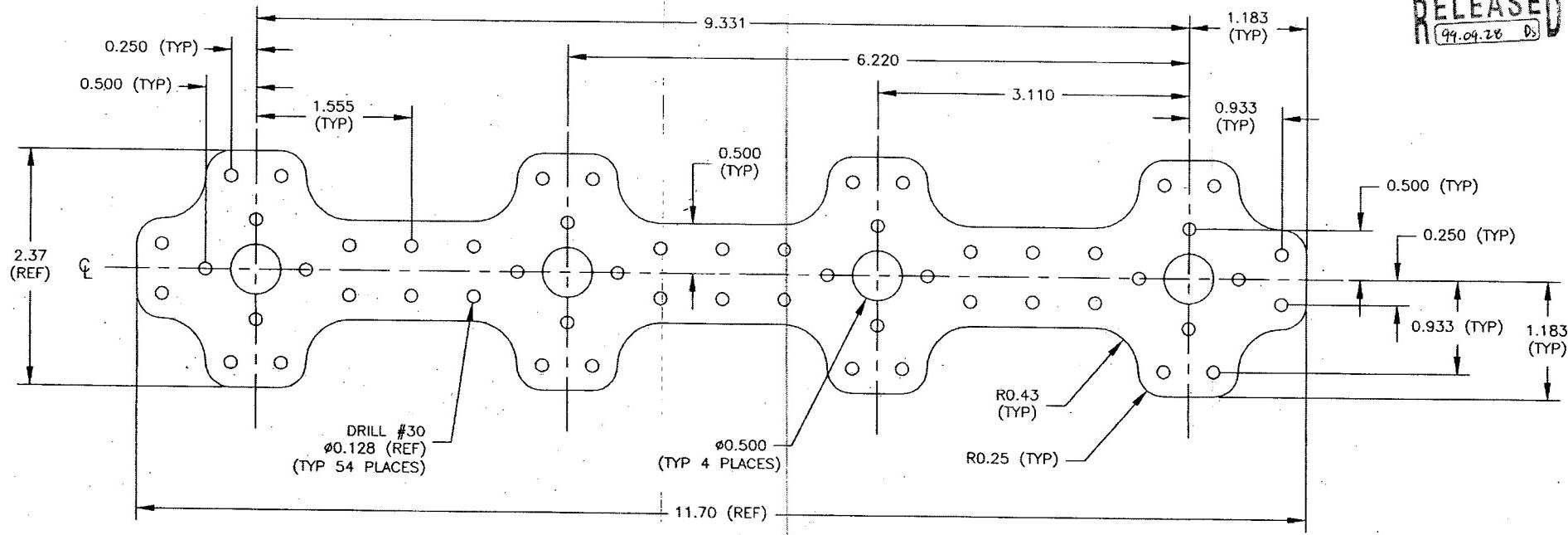
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>LB</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	8-1-29	Date:	08/01/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>✓</i>	E

RELEASED  
99.04.28 D



FLAT PATTERN

36927  
NO. 36927  
U BENDING DETAIL  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

SHOP COPY  
RETURN TO  
ENGINEERING

MATERIAL: 6061-T6 SHEET (QQ-A-250/11) 0.091" THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

A	99.09.07	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CP	RF	REV. A
CHECKED	APPROVED	DRAWING NO.
CP	BB	D2910
DATE		SHEET 1 OF 1
99.09.07		SCALE
		1:1
TITLE		DOUBLER